

Thursday, 2/14/2008 10:54:17 AM

Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REPLACEMENT WINDOW ASSEMBLY
Job Number : 37414	
Estimate Number : 11174	
P.O. Number :	Part Number : D3290041
This Issue : 2/14/2008 S.O. No. :	Drawing Number : D3290 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 37033	Material :
Written By :	Due Date : 2/22/2008 Qty: 12 Um: Each
Checked & Approved By : <u>08 02 14</u>	
Comment : Est. B 06.05.25 Added Step 11 KJ/JLM	
Est. C 06.05.09 Ecn 798 EC	
Est Rev:D Now on Waterjet 06-06-16 JLM	
Est rev E rev C dwg 07.09.28 EC verified by: DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 3.9375 sf(s)/Unit Total : 47.2500 sf(s) 5052 306900 X 9

M6061T6S040

Batch: 7106747 X 3 +

IB 8-2-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3290 ( use prog. for D3290-1)

Dwg Rev: C

Prog Rev: C

IB 8-2-15

2-Deburr if necessary

IB 8-2-15

08/03/12 (12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-2-15

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/03/12 (12)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(12X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:54:17 AM

User: Kim Johnston

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Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING



M1007005



(12x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 08/03/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Qm 08.03.15 (12)

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 78.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description

Batch

B34718 (3)

1 D2126-0780 Locking Seal

B35257 (9)

SAD 08/03/30 (12)

9.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Window

Pick:

Qty Part Number Description

Batch

B34957

1 D3290-3 Window

AS 08/03/18 (12)

10.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 08/03/30 (12)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/31 (17)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 50218

PC 8/3/31 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:54:17 AM  
User: Kim Johnston

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Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 37414

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/01/02  
JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf  
U

08-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

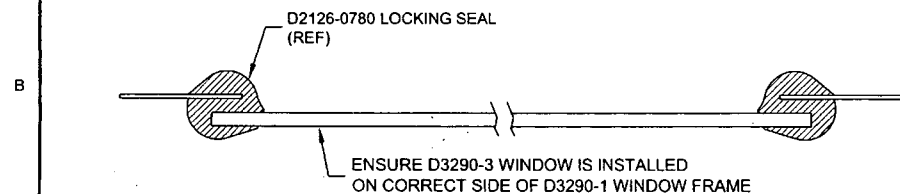
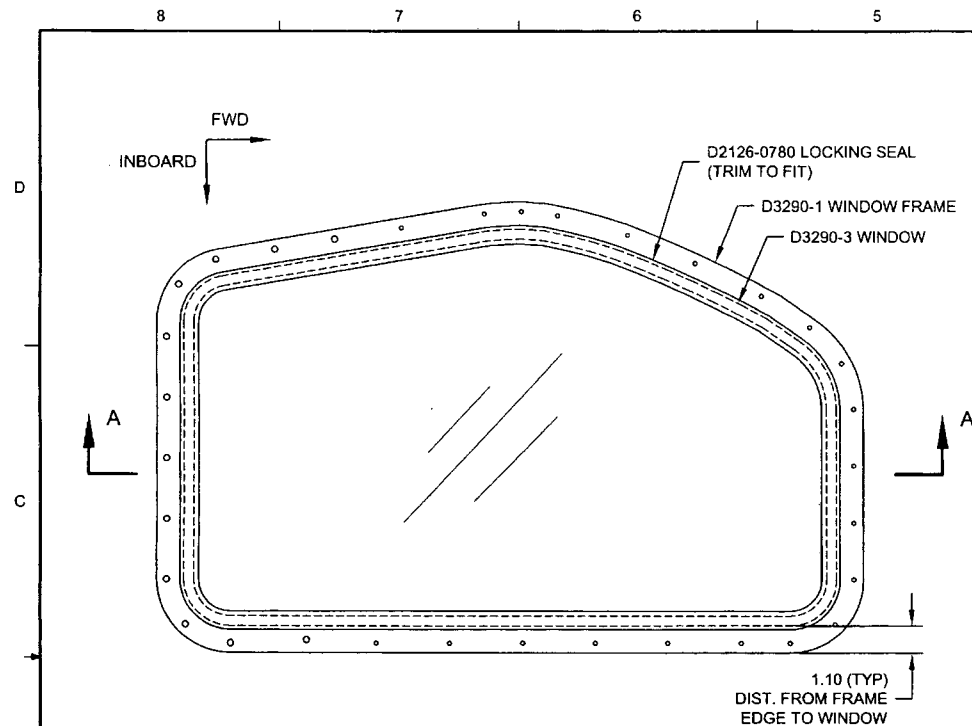
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





**SECTION A-A**  
NTS

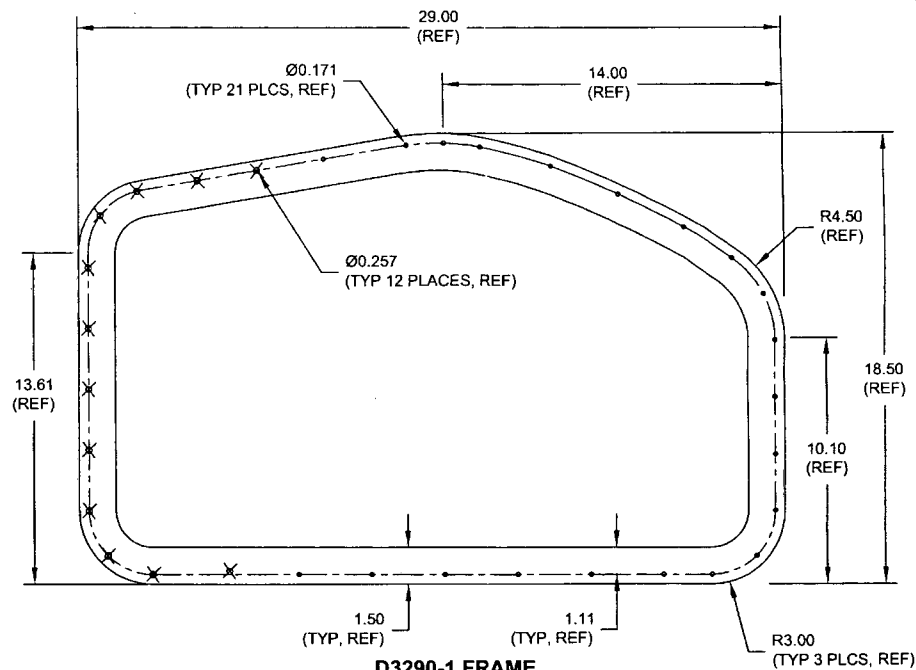
**D3290-041 REPLACEMENT WINDOW ASSEMBLY**

**D3290-041 NOTES:**  
1) WEIGHT: 3.66 LBS

**GENERAL NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED







NO. 37414  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY



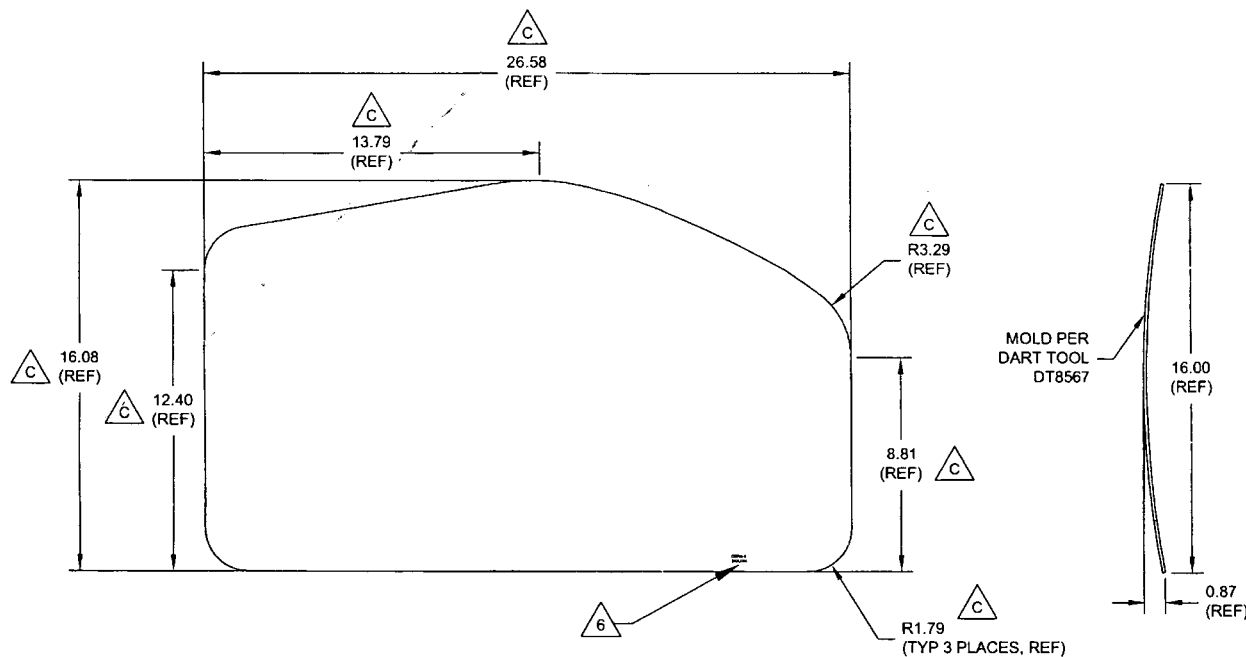
**D3290-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

**RELEASED**  
07.07.24

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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### D3290-3 WINDOW

#### D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER  
LP-391 TYPE 1 GRADE C, 0.125 THICK  
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

RELEASED  
07.07.22

NO. 3744-14  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD